

Date: Thursday, 11/15/2007 7:34:51 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 35738	
Estimate Number : 13066	
P.O. Number : <i>NA</i>	Part Number : D36811
This Issue : 11/15/2007 S.O. No. : <i>NA</i>	Drawing Number : D3681 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : <i>NA</i>	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 11/23/2007 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.11.15	
Comment : Est Rev A new issue 07-10-30 DD verified by:	
Est Rev:B Ecn 1056 Rev A dwg DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM. SEAMLESS TUBE
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Comment: Qty.: 0.0307 f(s)/Unit Total : 1.5330 f(s)

Material:

(M6061T6T0.313W.058)

Batch: *11106347**RD 07/11/28*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: *A*DWG REV: *A*

2-DEBURR AS REQUIRED

RD 07/11/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RD 07/11/28**(51)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.F.**07/11/28**(51)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG**BE 07/11/28*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 7:34:51 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 35738

Part Number: D36811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

2011/28

Job Completion



U 8/11/29

Dart Aerospace Ltd

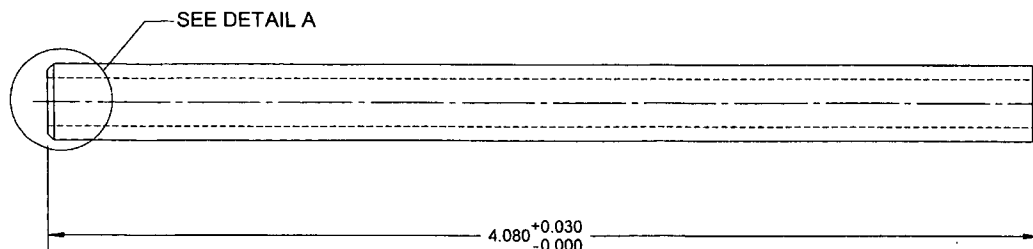
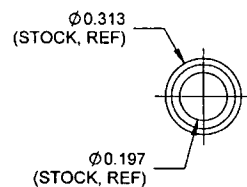
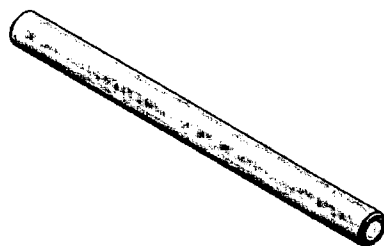
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

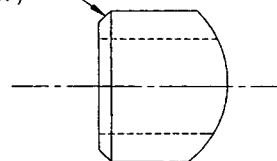
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

D3681-1 SPACER

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 35738

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
 PER WW-T-700/6 OR AMS 4080 OR AMS 4082
 OR QQ-A-200/8 OR QQ-A-225/8
 (REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-09

A NEW ISSUE		DC		07.11.08
REV.	DESCRIPTION	BY	DATE	
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, VA		
DRAWN	SC			
CHECKED	MD	DRAWING NO. D3681		REV. A
MFG. APPR.	EP	TITLE SPACER		SHEET 1 OF 1
APPROVED	W			SCALE 2:1
DE APPR.	W			
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		

